

MUST SHIP WED 29/11

Dart Aerospace Ltd.

Date: Thursday, 11/23/2006 1:09:51 PM
User: Kim Johnston

OIL SOONER

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT RH (FOLDING)
Job Number	: 29685		
Estimate Number	: 11653		
P.O. Number	: N/A	Part Number	: D2801042
This Issue	: 11/23/2006 S.O. No. : N/A	Drawing Number	: D2801 REV A 1 UP 061123
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A 1
Previous Run	: 27848	Material	: N/A
Written By	: <u>HJ 061123</u>	Due Date	: 11/29/2006 Qty: 2 Um: Each
Checked & Approved By	: <u>HJ 061123</u>		
Comment	: Est B01.04.26 Changed D2802-042 to -2 EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

B28215

Check Material for any Dents or Defects

PE 06-11-23 2

PE 06-11-23 2

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801

2-Deburr and bevel ends for welding

PE 06-11-23 2

PE 06-11-23 2

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PE 06/11/23 (2)

4.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap

B27281

PE 06-11-23 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 1:09:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 29685

Part Number: D2801042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D28022

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2802-2

Arm

324688 = 1
325709 = 3

PE. 06-11-24

✓
2

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms as per Dwg D2801

2-Weld one end cap as per Dwg D2801

3-Grind end cap welds flush

PE. 06-11-24

PE. 06-11-24

PE. 06-11-24

✓
2
2
2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/11/27 (2)

✓

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/11/27 (2)

✓

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 06/11/27

(2)

✓

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE. 06-11-27

✓

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap as per dwg D2801

2-Grind welds flush

PE. 06-11-27

PE. 06-11-28

✓
2
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 1:09:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 29685

Part Number: D2801042

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RA 06/11/28 (2)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RA 06/11/28 (2)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch-up alodine

a.m

06/11/28

(2)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/11/28

(2x)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06/11/28 (2)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2801 and QSI 005 4.4

M 102635

a.m

06/11/29 (2x)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 06/11/29 (2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

REV A1

LB 06/11/29

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PP Date: 06/11/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 29685

Part Number: D2801042

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/29 (2)

Job Completion



W 06.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

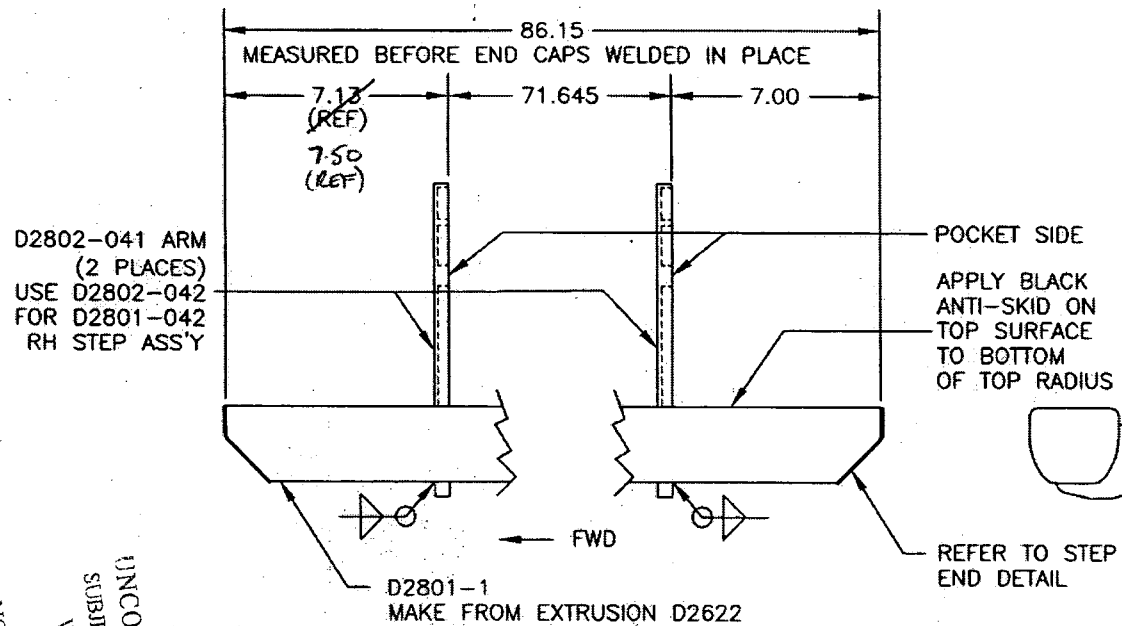
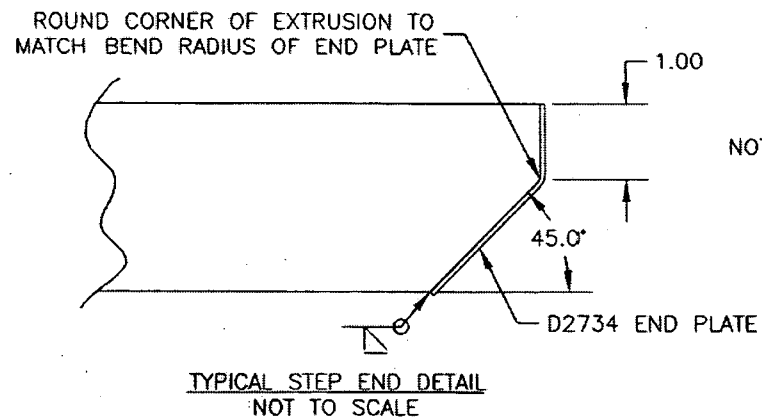
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D2801	SHEET 1 OF 1
00.11.03		TITLE	SCALE
		STEP WELDMENT	NTS
A	00.11.03	NEW ISSUE	
A1	03.08.16	7.50 WTS 7.13	

RELEASED
00.11.13

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

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